

Date: Thursday, 05/02/2009 3:47:26 PM
User: Julie Dawson

Process Sheet

Split

| | | | |
|-----------------------|--|------------------|----------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BASKET (A119) ARMS |
| Job Number | : 45567 -2 | Part Number | : D3518041 |
| Estimate Number | : 12443 | Drawing Number | : D3518 REV.B |
| P.O. Number | : | Project Number | : N/A |
| This Issue | : 05/02/2009 S.O. No. : | Drawing Revision | : B |
| Prsht Rev. | : NC | Material | : |
| First Issue | : / / Type : R & D SM/MED FAB | Due Date | : 03/03/2009 |
| Previous Run | : 38933 | Qty: | 7 |
| Written By | : | Um: | 10 |
| Checked & Approved By | : <u>JD 09.02.06</u> | Each | |
| Comment | : EST rev A 05.06.06 preliminary EC est rev B 06.07.31 re-design EC est rev C 07.04.09 revB dwg EC | | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D23245

Strap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Strap

Batch: 39638

(-13)

2.0

D35181

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

FWD ARM

Batch: B 46037

-10

3.0

D35183

Stainless Steel Ball Joint Rod End



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

AFT ARM

Batch: B39029

4.0

AN313A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

Batch: M 104746

(-13)

5.0

AN316C6R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nut

Batch: M1962x5 M6289x5

Handwritten notes:

- Quoted for return to stock 4/9/2003
- 8/8/09/02/17 (X10)
- 8/8/09/02/24 (X10)
- 8/8/09/02/17 (X10)
- 8/8/09/02/17 (X10)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:47:26 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET (A119) ARMS

Job Number: 45567

Part Number: D3518041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

Batch: M110139 (-25)

SS 09/02/17 (x10)

7.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Batch: M109798 (-14)

SS 09/02/17 (x10)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3518

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Part # D3518-041 using fine point permanent ink marker and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

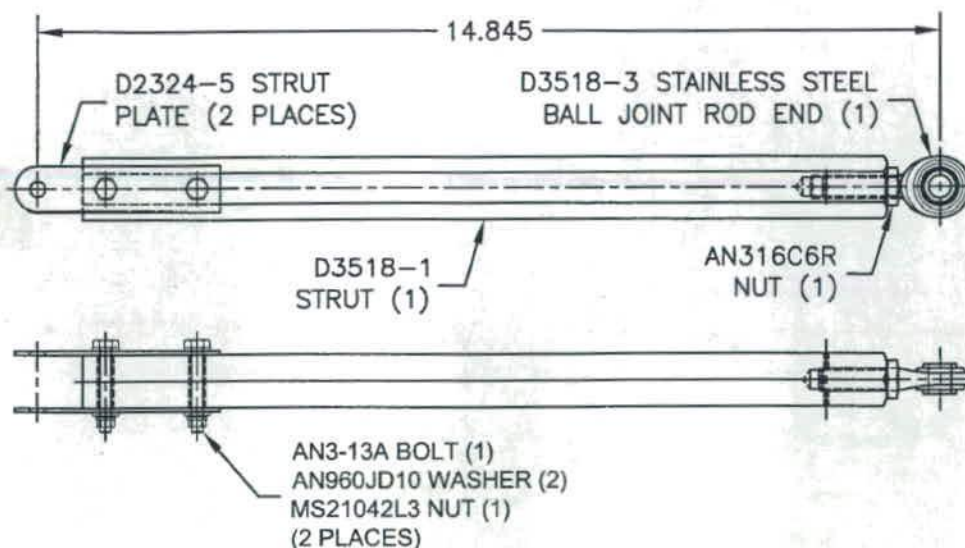
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3518 | REV. B SHEET 1 OF 3 |
| DATE 06.10.23 | | TITLE BASKET (A119) STRUT | SCALE 1:3 |
| A | 06.06.21 | NEW ISSUE | |
| B | 06.10.23 | RE-DESIGN | |

**D3518-041 STRUT ASSEMBLY**

| QTY -041 | Part Number | Description |
|-------------|-------------|------------------------------------|
| X | D3518-041 | STRUT ASSEMBLY |
| 2 | D2324-5 | STRUT PLATE |
| 1 | D3518-1 | STRUT |
| 1 | D3518-3 | STAINLESS STEEL BALL JOINT ROD END |
| 2 | AN3-13A | BOLT |
| 1 | AN316C6R | NUT |
| 4 | AN960JD10 | WASHER |
| 2 | MS21042L3 | NUT |

NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

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NO. 45567

RELEASED

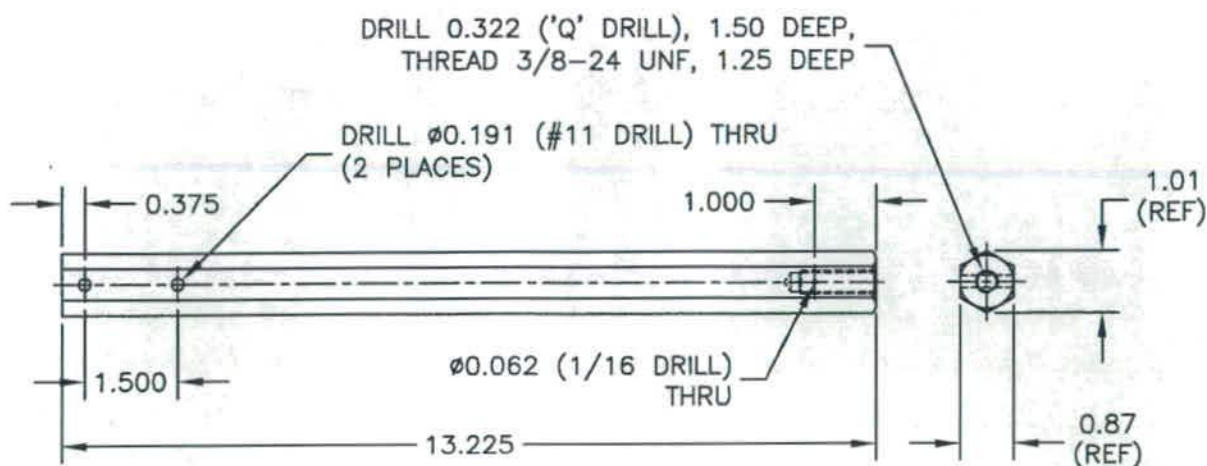
06.11.17 *[Signature]*

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| | | | |
|----------------------|------------------------------|---|------------------------|
| DESIGN <i>B</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>H</i> | DRAWING NO. D3518 | REV. B SHEET 2 OF 3 |
| DATE 06.10.23 | TITLE BASKET (A119) STRUT | | SCALE 1:3 |



D3518-1 STRUT

NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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RELEASED

06.11.17 *H*

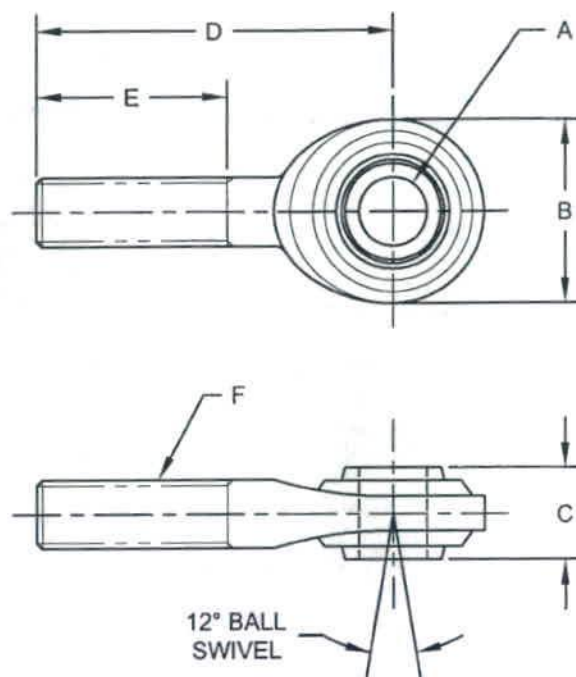
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DART

| | | | |
|------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED PH | APPROVED <i>[Signature]</i> | DRAWING NO. D3518 | REV. B SHEET 3 OF 3 |
| DATE 06.10.23 | | TITLE BASKET (A119) STRUT | SCALE 1:1 |

SPECIFICATION CONTROL DRAWING



| DART P/N | A | B | C | D | E | F | LOAD* | POSSIBLE SUPPLIER |
|----------|-------|------|------|-------|------|-------------------|-------|-------------------------------|
| D3518-3 | 0.375 | 1.00 | 0.50 | 1.938 | 1.25 | 3/8-24 UNF, RH | 4012 | McMASTER-CARR, P/N 2458K14 |

* Indicated load is Static Radial Load Capacity in lbs

NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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06.11.17 *[Signature]*

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